ASAP

PRELIMINARY ISSUE 11.10.04

Work Order ID 74049

Wednesday, September 21, 2011 8:50:07 AM

Item ID: D3805-5 **Accept**

Revision ID:

Item Name: Plate

Setup Start / Stop

Start Date: 9/21/2011 **Start Qty:** 20.00

Required Date: 9/29/2011 **Req'd Qty:** 20.00

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ✓ **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Run Start / Stop

Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3805	Revision Nbr: ~~PB1~~ B	11.10.04 ECN 11-640								
100			0.00							
Waterjet		Memo	0.00				FB11-9-22			
FLOW CNC Waterjet		1-Cut as per Dwg D3805 Dwg Rev: PB1 Prog Rev: PB1 2-Deburr if necessary					(20)			
110	QC2- Inspect parts off machine FAI/FAIB		0.00							
QC Quality Control		Memo	0.00				FB11-9-22			

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ________________ **Disposition:** ______________ **QA: N/C Closed:** _________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74049

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Stop

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Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 -inspector to PB1				counted ✓20			
QC Quality Control	**Memo**	0.00 Dwg only 8 wks/22							
130		0.00				20			
Brake NC Brake NC	**Memo** Form as per Dwg D3805 using Jigs DT8261and DT8326	0.00 SB 11/09/26							
140	QC5- Inspect part completeness to step on W/O	0.00 -inspector to PB1							
QC Quality Control	**Memo**	0.00 Dwg only 8 wks/26 counts ✓20							

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _____ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 74049

Wednesday, September 21, 2011 8:50:07 AM

Item ID: D3805-5 **Accept** **Setup** **Start**

Revision ID:

Item Name: Plate **Stop**

Start Date: 9/21/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 9/29/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run** **Start**

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging Packaging	Identify as per dwg & Stock Location: W/A	0.00				12	11-9-28		
	Memo	0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00					11/10/4		
	Memo	0.00							

MF 11-09-28

POSITIVE RECALL
EFFECTIVE 11/9/21 AUTH
RELEASED ______ DATE 11.16.04
ECN 11-640

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 8:50:05 AM

Work Order ID: 74049

Parent Item: D3805-5

Parent Item Name: Plate

Start Date: 9/21/2011 **Required Date:** 9/29/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	205.5550	1.587	33.41053		B 11-9-22	

Location		Loc Qty	Loc Code
MAT020		64.655	
	113062	0.155	
	116979	64.5	
MAT021		140.9	
	118217	140.9	118217

(20)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: __________ **PAR #:** ______ **Fault Category:** __________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: __________ **Disposition:** __________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44049
Description: Wearplate	Part Number:	D3805-5
Inspection Dwg: D3805 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010	.401	x		V PB02	
0.050	+/-0.010	.050	x		V	
0.875	+/-0.010	.875	x		V	
0.125	+/-0.010	.127	x		V	
0.938	+/-0.010	.937	x		V	
Ø0.188	+0.005/-0.001	.190	x		V	
5.320	+/-0.010	5.321	x		V	
3.00	+/-0.030	3.003	x		V	
3.850	+/-0.010	3.857	x		V	
25.225	+/-0.010	25.225	x		T PB01	
39.425	+/-0.010	39.428	x		T	
43.50	+/-0.030	43.50	x		T	

Measured by:	KB
Date:	11-9-21

Audited by:	S
Date:	11/09/22

Prototype Approval:	N/A
Date:	N/A

to PB1 Dwg only

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

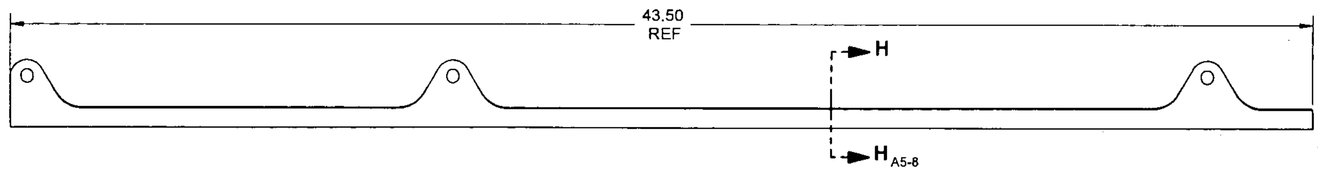
Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

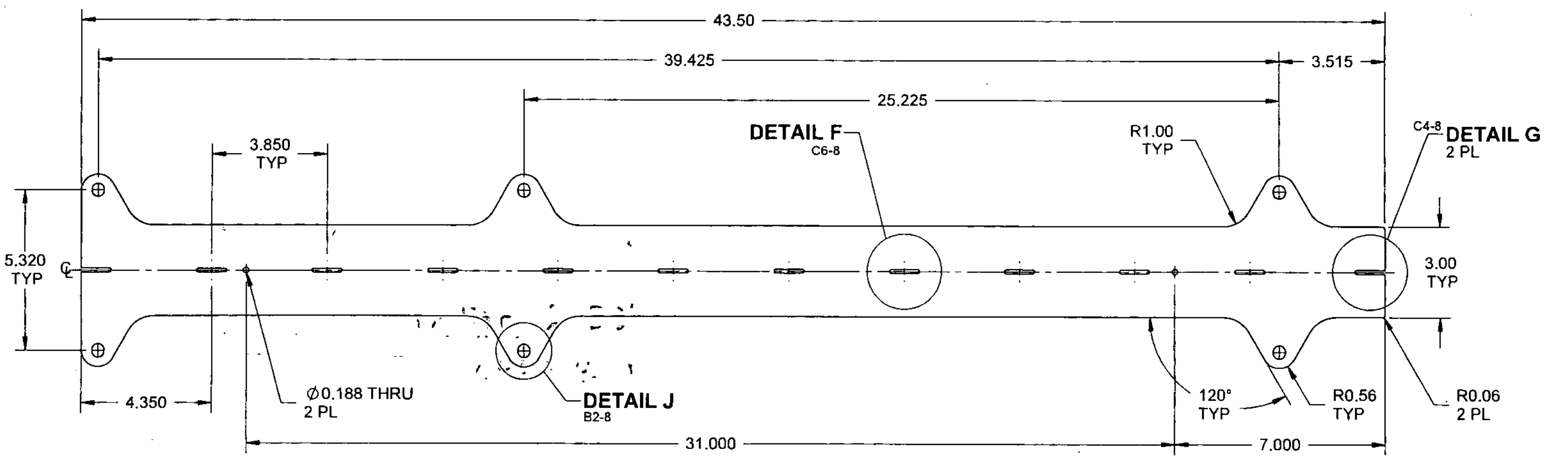
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D3805-5 PLATE
(MAKE FROM D3805-5F)



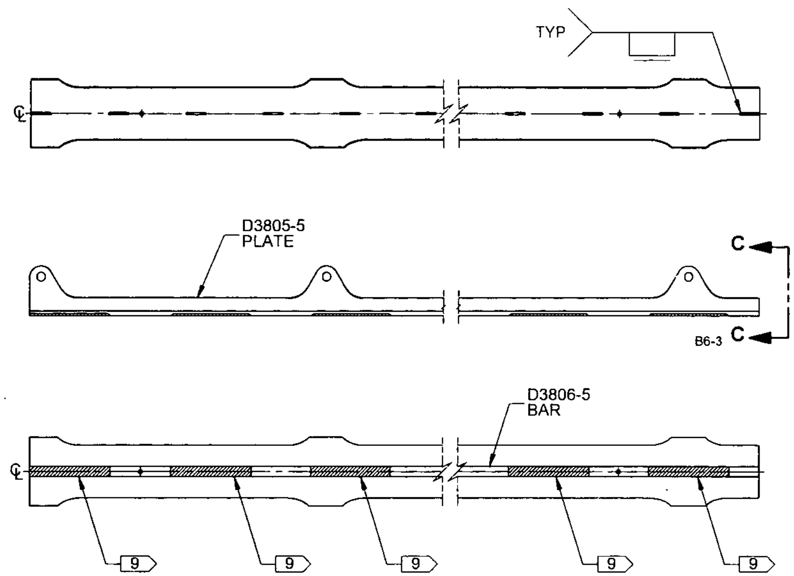
D3805-5F PLATE

PRELIMINARY ISSUE 11.09.16

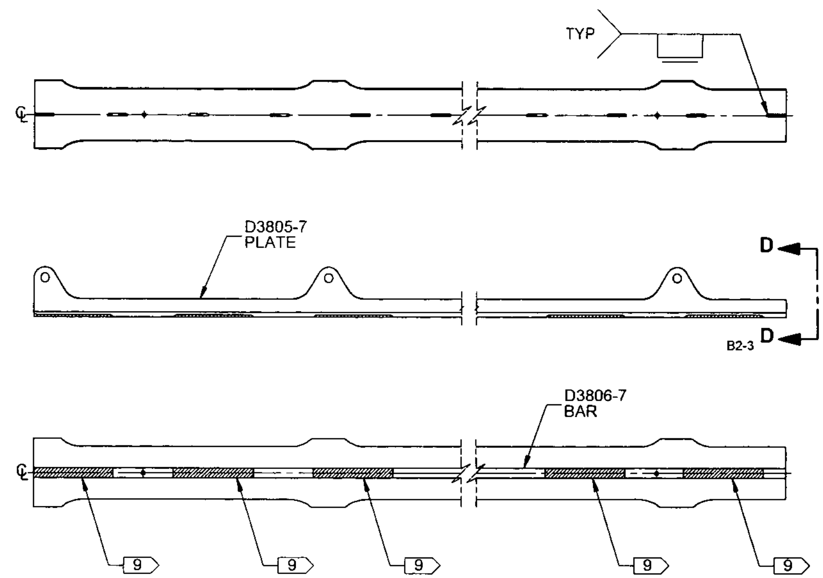
NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.06 lbs

DESIGN		DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D3805 — REV. PB1 — SHEET 6 OF 8
MFG. APPR.		
APPROVED		TITLE WEARPLATE ASSY — SCALE NTS
DE APPR.		
DATE	11.09.16	

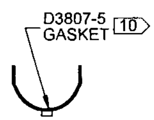
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D3805-045 AFT WEARPLATE ASSY,

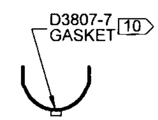


D3805-047 AFT WEARPLATE ASSY,



VIEW C-C C5-3

PRELIMINARY ISSUE
11.09.16

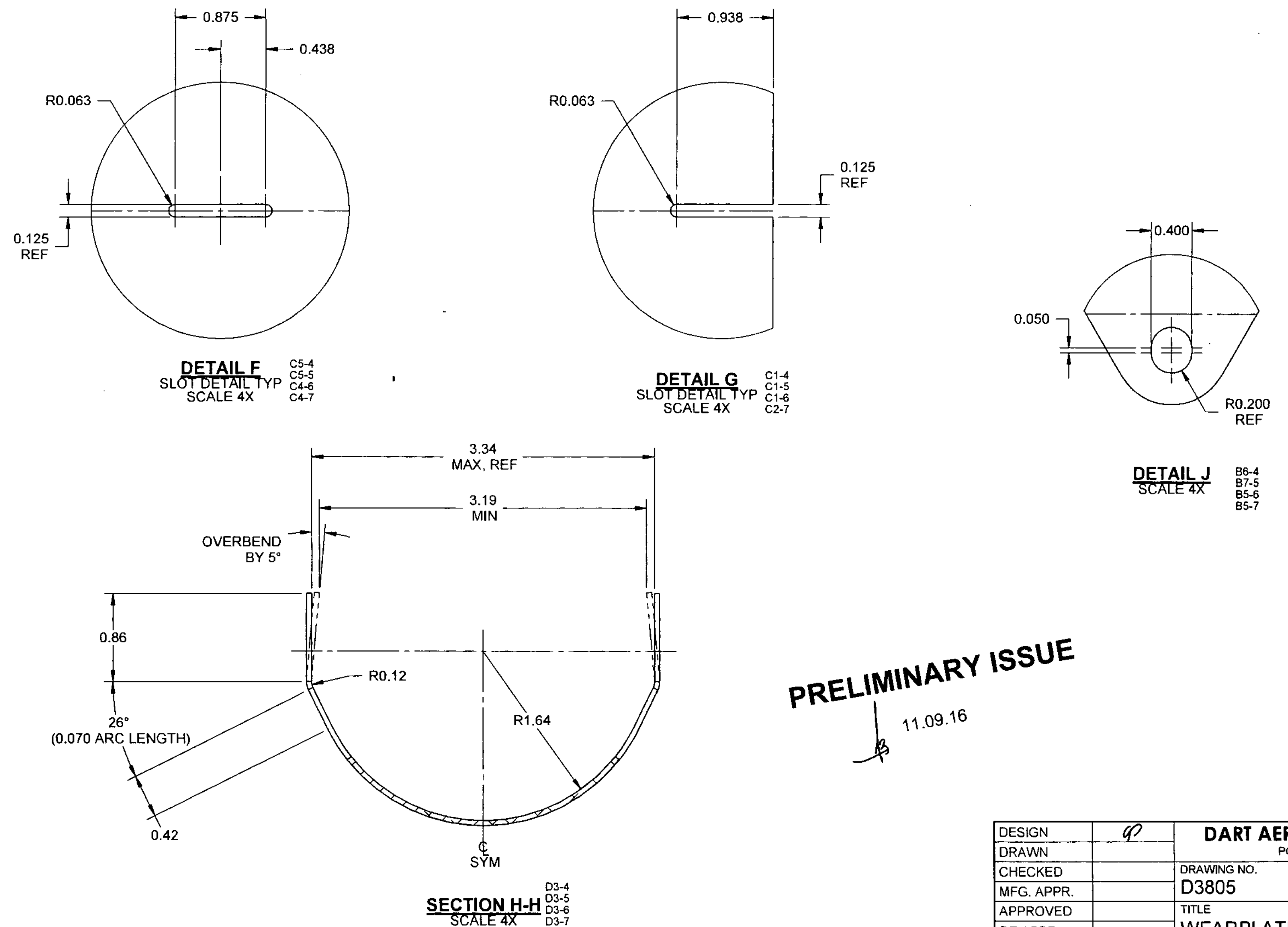


VIEW D-D C1-3

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.21 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

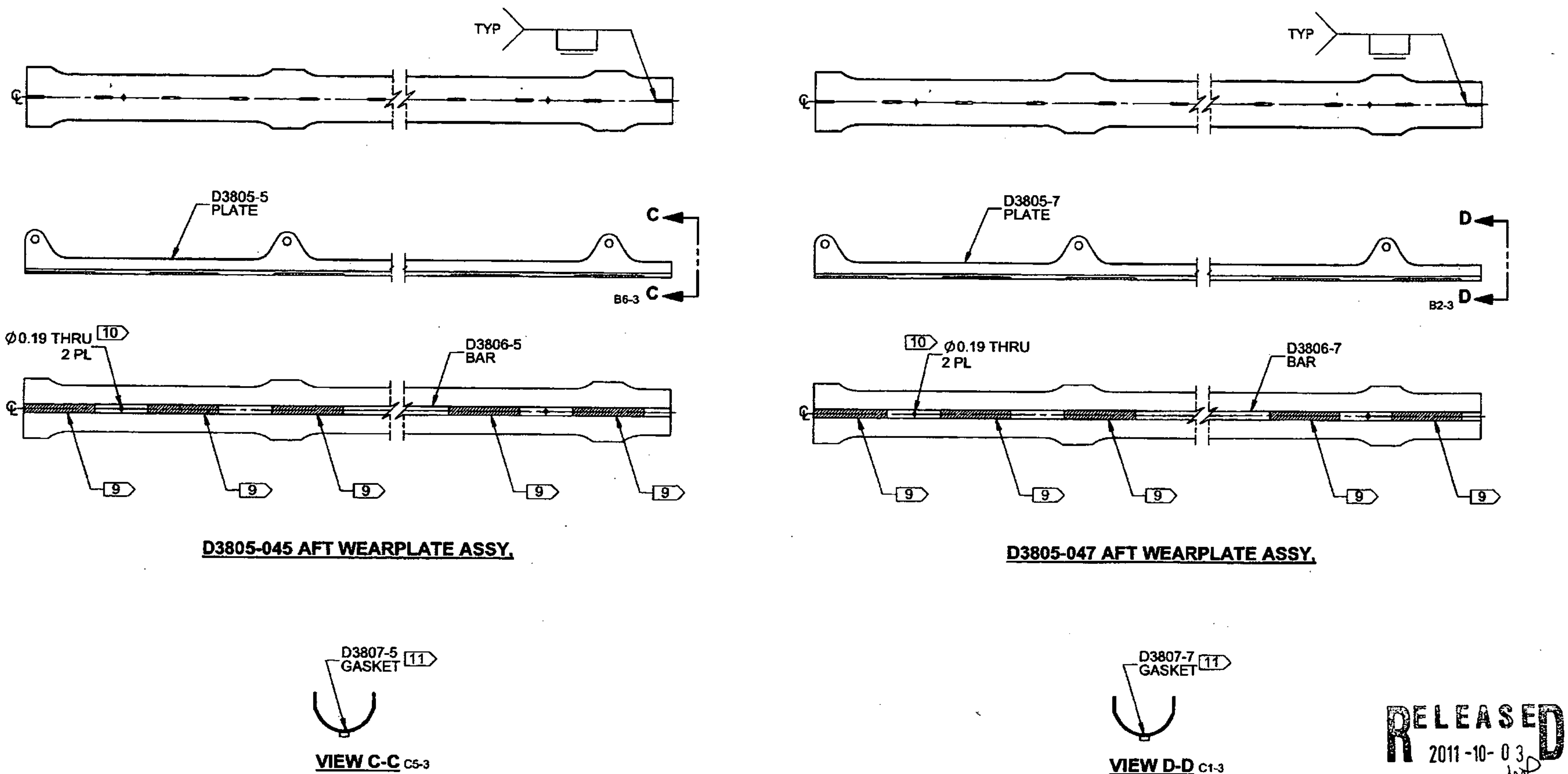
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DRAWN		DRAWING NO. D3805 — REV. PB1 — SHEET 3 OF 8
CHECKED		
MFG. APPR.		TITLE WEARPLATE ASSY — SCALE NTS
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DRAWN		DRAWING NO. D3805 — REV. PB1 — SHEET 8 OF 8
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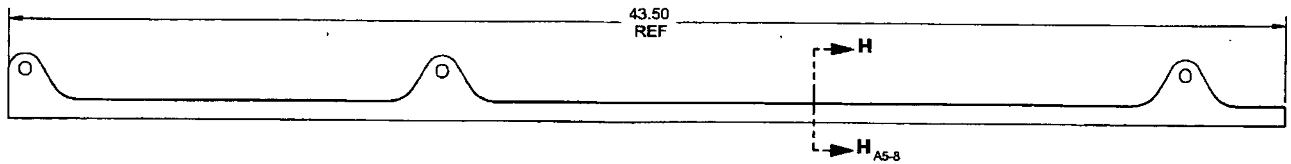
RELEASED 2011-10-03

NOTES: B

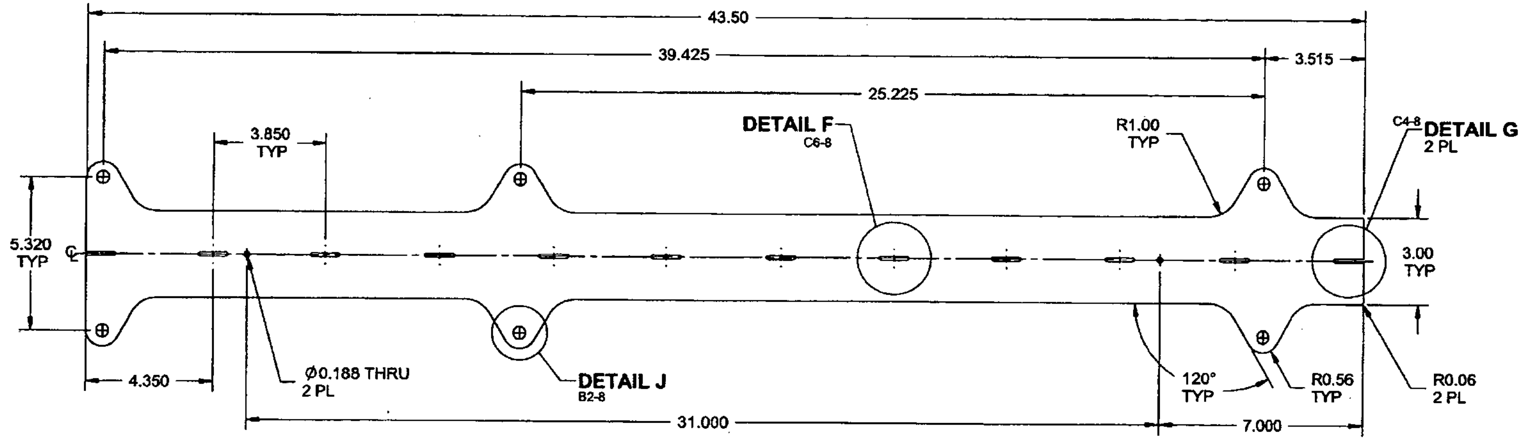
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3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
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7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
8) WELDING: PER QSI 004
9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D3805 — REV. B — SHEET 3 OF 8
MFG. APPR.		
APPROVED		TITLE WEARPLATE ASSY — SCALE NTS
DE APPR.		
DATE	11.09.16	

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D3805-5 PLATE
(MAKE FROM D3805-5F)



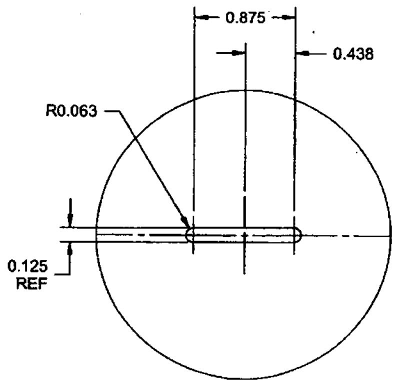
D3805-5F PLATE

RELEASED
2011-10-03

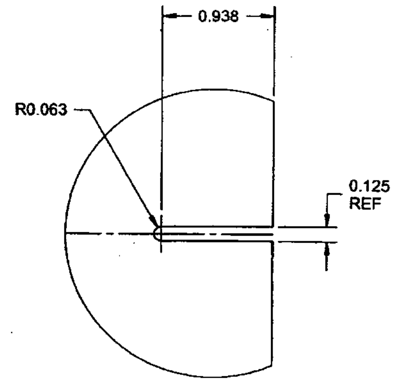
NOTES:
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18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.06 lbs

DESIGN		DART AEROSPACE USA, INC. KENT, WA
DRAWN		
CHECKED		DRAWING NO. D3805 — REV. B — SHEET 6 OF 8
MFG. APPR.		
APPROVED		TITLE WEARPLATE ASSY — SCALE NTS
DE APPR.		
DATE	11.09.16	

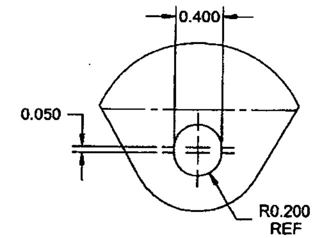
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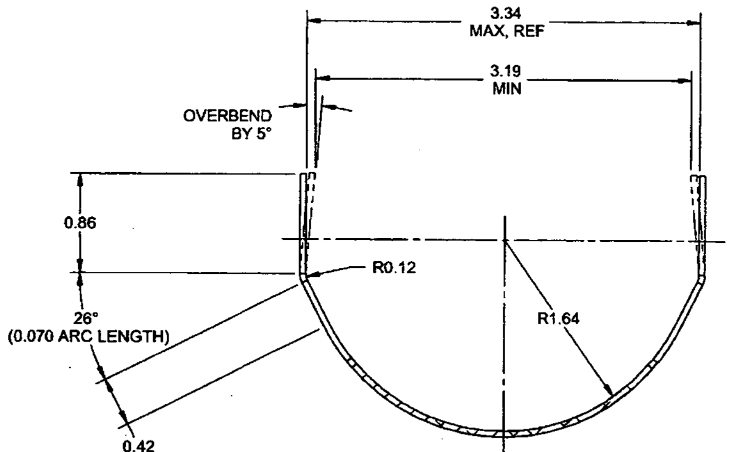
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4 C5-5 C4-6 C4-7



DETAIL G
SLOT DETAIL TYP
SCALE 4X
C1-4 C1-5 C1-6 C2-7



DETAIL J
SCALE 4X
B6-4 B7-5 B5-6 B5-7



SECTION H-H
SCALE 4X
D3-4 D3-5 D3-6 D3-7

RELEASED 2011-10-03

DESIGN		**DART AEROSPACE USA, INC.** KENT, WA
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